

Work Order ID 79379

Wednesday, January 25, 2012 11:47:53 AM

79379

Page 1

Item ID: D350-567-141

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Window Closeout Installation

Start Date: 1/25/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *P* Date: 12-01-25 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9590	A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-567-141 CHG001

Sr 1/6/31

ML 12-1-31

Pro

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

SP 12-01-31

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Sr 1/6/31

(76)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		ADD DSZ					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-141 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ME
12-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, January 25, 2012 11:48:07 AM

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Work Order ID: 79379

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Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM
12.01.23 AS PER ECN12-511 DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3802-1		Manufactured	No			110	f	588.3800	2	2			
---------	--	--------------	----	--	--	-----	---	----------	---	---	--	--	--

D3802-1

Window Seal

**

SP

Location

Loc Qty

Loc Code

ST412

588.38

56881

588.38

2

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

D4434-041		Manufactured	No			110	Each	0.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4434-041

Fwd Bracket Assembly

**

B79380 SP

D4434-047		Manufactured	No			110	Each	2.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4434-047

Cover Assembly

**

B79381 SP

Location

Loc Qty

Loc Code

PRE

1

77915

1

prelim

1

74814

1

D4435-045		Manufactured	No			110	Each	1.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4435-045

T/R Bellcrank Cover Assembly

**

B79382 SP

12-01-31

Location

Loc Qty

Loc Code

ENG

1

77926

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 79379

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Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

D4435-9 Manufactured No

110 Each

2.0000

2 2

D4435-9

Bracket

**

B79383. Q

Location

Loc Qty

Loc Code

ENG

2

77927

2

D4436-041

Manufactured No

110 Each

1.0000

1

D4436-041

Aft Bracket Assembly

**

B79384 1x0.

Location

Loc Qty

Loc Code

ENG

1

77907

1

D4441-1

Manufactured No

110 f

35.4840

2

2

D4441-1

Rubber Seal

**

SP

Location

Loc Qty

Loc Code

prelim

35.484

74760

35.484

2

(D4441-1-240) CUT (1) AT 24.00" PER KIT

AN3-3A

Purchased No

110 Each

134.0000

7

7

AN3-3A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST350

134

120187

134

110 Each

0.0000

9

9

AN525-632R6

Purchased No

AN525-632R6

Screw

**

7x

MS35206-228

sec 2 attached

Wednesday, January 25, 2012 11:48:07 AM

Shop Packet Print

Page 2

NAS 1149 ENG 16P

x9

x9

B 111578

B 117317

12-02-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

AN525-10R6

Purchased

No

110

Each

82.0000

2 2

AN525-10R6

Screw

**

SP

Location

Loc Qty

Loc Code

ST345

50

120308

50

ST346

32

118757

23

119309

9

110

Each

624.0000

9

2x

9

**

SP

MS21042L06

Purchased

No

MS21042L 06

Nut

Location

Loc Qty

Loc Code

ST300

624

118354

2

119109

100

119758

22

120360

500

110

Each

5,526.000

5

8x

5

**

SP 12-01-31

MS21042L3

Purchased

No

MS21042L 3

Nut

Location

Loc Qty

Loc Code

ST300

5526

117441

16

117885

32

118451

5

118927

3

119017

5005

119075

465

5x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

MS21059L3

Purchased

No

110

Each

323.0000

2

2

MS21059L3

Nut Plate

**

SP

Location

Loc Qty

Loc Code

ST301

123

~~118614~~

23

~~119546~~

100

ST302

200

120308

200

~~2x~~
2x

NAS1149F0332P

Purchased

No

110

Each

268.0000

12

12

NAS1149F0332P

WASHER

**

SP

Location

Loc Qty

Loc Code

ST275

268

117735

37

~~119225~~

228

17317

3

12x
9

NAS1149FN616P

Purchased

No

110

Each

200.0000

9

9

NAS1149FN616P

WASHER

**

SP 12-01-31

Location

Loc Qty

Loc Code

ST275

200

117317

200

9x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
9	AN525-632R6	SCREW
2	AN525-10R6	SCREW
9	MS21042L06	NUT (OR MS21042-06)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
12	NAS1149F0332P	WASHER (AN960-10L)
9	NAS1149FN616P	WASHER (OR AN960-6L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:




- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 — OK to remove D3295-041
 - D350-567-031 — OK to remove D3212-1
 - D350-567-011 — OK to remove D2214
 - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 12.01.09
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 12
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	12.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Linda Lacelle

From: Roberto Fuentes <rfuentes@dartaero.com>
Sent: February-01-12 12:56 PM
To: 'Mike Petsche'; Linda Lacelle ; H. Siemens; David Shepherd
Subject: RE: CHL's screws

Ok, I check with Harvey, he recommended to change to MS35206-228 screw and add a washer, rather than increase the size of the hole at installation, so the part need to change as follow:

New

(9) MS35260-228 Screw

(18) NAS1149FN616P Washer

Was

(9) AN525-632R6 Screw

(9) NAS1149FN616P Washer

Thanks,

Roberto

From: Mike Petsche [<mailto:mpetsche@dartaero.com>]
Sent: Wednesday, February 01, 2012 9:58 AM
To: Roberto Fuentes; 'Linda Lacelle'
Cc: 'Harvey Siemens'; 'David Shepherd'
Subject: CHL's screws
Importance: High

Roberto

Apparently we have AN525 screws in 8-32. Apparently #6 does not exist.

I just called david, and he is ok with increasing the screws to the 8-32 for this delivery.

Can you please double check the p/n's you would need (screws washers nuts) to make the change FOR THIS SHIPMENT ONLY.....and we are hoping we have all of it in stock! (Linda is pretty sure we do).

Then could you please spec a #6 fastener to replace the one that was initially called out?

Thanks!